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D206-558-041
Job Sheet 183687



Part No: D206-558-041

Job Qty: 1 ea

Part Name: Single Mirror Installation



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/25/18

Job Tracking No:

Due Date: 10/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 13 IPP F 02.09.19 Re-format; Incorporated D2065 KJ IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD verified:ec IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec IPP Rev:I 10.03.17 add pick kit DD verified by:JLM IPP REV:J 11.01.19 AS PER CHG009 DD VERF:EC IPP REV:K 14.09.09 AS PER IIN REV.D DD VERF:JLM

Ship Via:

005747

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/23/18	10/23/18	0.00	0.00	Start Up Small Fab-4		OCT 0 2 2018
110	Small Fab	1 pcs	10/23/18	10/23/18	0.00	0.71	Small Fab-1		OCT 2 3 2018
120	QC	1 pcs	10/23/18	10/23/18	0.00	0.00	QC5		OCT 2 3 2018
125	Packaging	1 pcs	10/23/18	10/23/18	0.00	0.00	Packaging1-2		OCT 2 3 2018
130	QC	1 pcs	10/23/18	10/23/18	0.00	0.00	QC4		OCT 2 3 2018
140	Packaging	1 pcs	10/23/18	10/23/18	0.00	0.00	Packaging3-1		OCT 2 3 2018
145	DC	1 pcs	10/23/18	10/23/18	0.00	0.00	DC		OCT 2 3 2018
150	QC21-FG	1 Ea	10/23/18	10/23/18	0.00	0.00	QC21		OCT 2 3 2018

Part Op 110 - Assemble as per Dwg D206-558 PAGE 10 IN BLUE FILE

Descriptions: 140 - Identify and pack for shipping as per PPP D206-558-041

145 - Photocopy bluefile and type labels as per PPP D206-558-041 CHG009

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2011-101	Mirror 6"	1 Ea (1 ea)	90-Start up Operation	3107808
D2052	Bracket	2 Ea (2 ea)	90-Start up Operation	5027179
D2054	Bushing - Delrin	2 Ea (2 ea)	90-Start up Operation	5031100
D2055	Clamp	1 Ea (1 ea)	90-Start up Operation	5094937
D2056	Bell Crank Assembly	1 Ea (1 ea)	90-Start up Operation	5087342
D2057	Plug	1 Ea (1 ea)	90-Start up Operation	5119992
D2065	Mirror Arm	1 Ea (1 ea)	90-Start up Operation	5093578
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	5094592
MS27039-1-18	Screw	2 Ea (2 ea)	90-Start up Operation	5124320
NAS1149D0363J	Washer	4 Ea (4 ea)	90-Start up Operation	5095793
AN3-4A	Bolt	4 Ea (4 ea)	125-Packaging	5087363X2 / 50 60063X2
AN526-1032R9	Screw	4 Ea (4 ea)	125-Packaging	51187136-7
D2053	Bracket	1 Ea (1 ea)	125-Packaging	5100795
D2067	Connector	1 Ea (1 ea)	125-Packaging	5097101
D2071	Cable Assembly - 32"	1 Ea (1 ea)	125-Packaging	5072096
D3778-1	Bracket	1 Ea (1 ea)	125-Packaging	51163716
MS21042L3	Nut	1 Ea (1 ea)	125-Packaging	5094952

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

MS21919-DG5	Clamp	2 Ea (2 ea)	125-Packaging
MS35489-67	Grommet	1 Ea (1 ea)	125-Packaging
MS35489-9	Grommet	1 Ea (1 ea)	125-Packaging
NAS1149D0332J	Washer	6 Ea (6 ea)	125-Packaging

5893558
F121600
FM136044
J120407

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2011-101	1	11	0
	D2052	2	7	0
	D2054	2	9	0
	D2055	1	6	0
	D2056	1	8	0
	D2057	1	1	0
	D2065	1	10	0
	MS21042L3	2	3,077	0
	MS27039-1-18	2	1,240	0
	NAS1149D0363J	4	2,097	0
125-Packaging	AN3-4A	4	433	0
	AN526-1032R9	4	40	0
	D2053	1	5	0
	D2067	1	12	0
	D2071	1	12	0
	D3778-1	1	3	0
	MS21042L3	1	3,077	0
	MS21919-DG5	2	60	0
	MS35489-67	1	24	0
	MS35489-9	1	27	0
	NAS1149D0332J	6	1,698	0

Part Specifications

Specifications could not be found.

Plex 9/25/18 7:48 AM Dart.lajeunesse.marie

DAK!
AEROSPACE

Container No: S120459

Part: D206-558-041

Job No: 183687

Serial No/Batch: S120459

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-17 Issue 7 of 7
FAA STC SH1031NE 01/11/09, LBA GER

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www.dartaerospace.com

Howesbury, ON K64 1K7
CANADA

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052**	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054**	BUSHING
1	1	1	1	D2055**	CLAMP
1	1	1	1	D2056**	BELL CRANK ASSEMBLY
1		1		D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-5	CABLE ASSEMBLY
1	2	1	2	D3014-1*	LOCKNUT
1	1			D3778-1	BRACKET
		1	1	D3778-3	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	NAS1149D0416P*	WASHER (AN960JD416L)
4	4	4	4	NAS1149D0363P**	WASHER (AN960JD10)
6	6	6	6	NAS1149D0332P	WASHER (AN960JD10L)
3	1	3	1	MS21042-3	NUT (or MS21042L3)
	2		2	MS21042-3**	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18**	SCREW
1	1	1	1	MS35489-9	GROMMET
1	1	1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

** INCLUDED AS PART OF D2066 ARM (REF. -043/-047 ONLY)